

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029409**Date Inspected:** 13-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of Tower Electroslag Welds (ESW)

ESW N-044, Location A Face A,B:

QA performed Ultrasonic Testing (UT) on approximately 1000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW A" face A, B. Location (Y=8330~9330) of this weld was inspected using this testing method.

No recordable or transverse indications were observed in this repair area.

QA performed UT of weld designated as "ESW A" in accordance with the approved supplemental procedure for confirmation and evaluation of planar type defects. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Please see TL-6027 for complete listing of QA recorded indications.

In Process Visual Inspection

RWR201301-025

This QA observed, at random intervals, ABF/JV welder Chris Bruce performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and in accordance with ABF Welding Procedure Specification (WPS) ABF-WPS-D1.5-1000R-03. Welding was performed on tower Electroslag Weld "ESW"

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## WELDING INSPECTION REPORT

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designated as N.

Face A

Y= 7840 mm

L= 320 mm

W= 70 mm

D= 40mm

During welding, ABF Quality Control Inspector (QC) Andrew Keech was observed monitoring the welding parameters.

### Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to testing and work performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Adame,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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